

Date: Friday, 7/21/2006 7:36:55 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 28014	
Estimate Number : 10178	
P.O. Number : <i>N/A</i>	Part Number : D25941
This Issue : 7/21/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2594 REV B1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B1
Previous Run : 26364	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 8/8/2006
Checked & Approved By : <i>[Signature]</i> 06.07.21	Qty: <i>511</i> Um: <i>500</i> Each
Comment : Est D 02.08.22 Make in Cobra KJ	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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Comment: Qty.: 0.0547 f(s)/Unit Total : 27.3525 f(s)  
 Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8)  
 1100-0 (QQ-A-225/1) Ø0.625" Rod  
 (M5052H32R0.625) or (M6061T6R0.625) Batch *M101421*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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*PG**Issue f.d 2020**CJ06/09/13 511*

Comment: HARDINGE CNC LATHE SMALL

1-Make as per Dwg D2594-1 and Folio FA262.

2-Break all sharp edges 0.010 max.

*Make per drawing D2594 Rev. B1**Receive + Inspect for transit damage PG/9/13*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*N/A*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC5	SECOND CHECK
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Comment: SECOND CHECK

*Inspect Level 5**05/09/14**511*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and alodine as per QSI 005 4.1

*FC 06 09 14 (511)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:   *DP*   Date: 06/09/19

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: PLUG

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

FL 06 09 18 51

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m. 06-09-19 51

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location FDIS

FL 06 09 19 51

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/09/19 51

Job Completion



L2 06-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

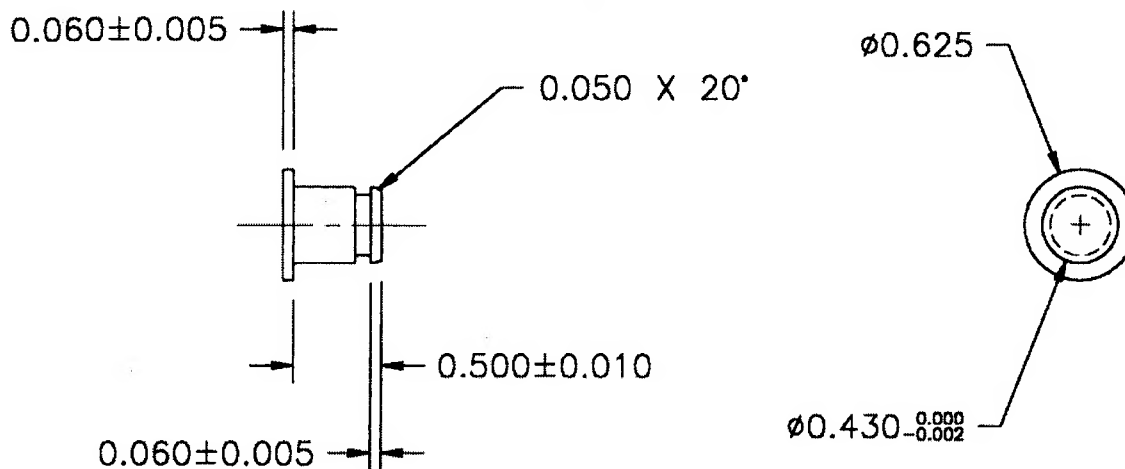




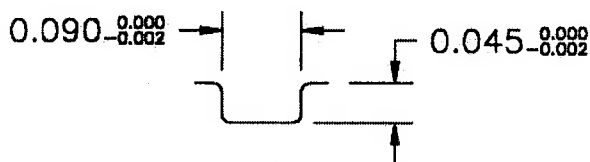
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2594	REV. B SHEET 1 OF 1
DATE 96:09:16		TITLE PLUG	SCALE 1:1
B	97:03:15	ADD GROOVE AND O-RING	
B1	RF 02.08.26	ADD POWDER COAT, QSE 018, & QQ-A SPECS.	

D2594-1 PLUG:

RELEASED  
97/03/27 DS



GROOVE DETAIL (SCALE 5:1)



TOLERANCES ARE PER DART QSE 018 UNLESS OTHERWISE NOTED.

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-O

FINISH: ACID ETCH, ALODINE

POWDER COAT WHITE (REF. 43.S.1) PER QSE 005 4.3

PER QQ-A-225 / 7 (5052)  
OR QQ-A-225 / 8 (6061)  
OR QQ-A-225 / 1 (1100)  
OR QQ-A-200 / 8 (6061)

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH  
(PARKER 2-011)

SHOP COPY  
RETURN TO  
ENGINEERING

D2594 PLUG ASSEMBLY INCLUDES:

- (1) D2594-1 PLUG
- (1) D2594-3 O-RING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28014



**CERTIFICATE OF CONFORMITY**

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

511

D 2594-1

Plug

910 2020  
Linda

MATERIAL: supplied by DART / Batch # M101421 ✓

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi (Regula) Walz



Vankleek Hill, September 13, 2006